

# Work Order ID 82306

March-28-12 2:33:00 PM

**\*82306\***

Page 1

Item ID: D3826-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib / Gusset Assembly  
 Start Date: 28/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/28 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3826	Rev B

100 Large Fab -0.00  
**\*100\***  
 Large Fab Memo 0.00  
 Large Fab 1- assemble D2325 support gusset together  
 2- locate D2325 on rib and weld as per dwg D3826  
 A/R ER316 S.S. Rod Batch: 1112357  
DSA 12-05-27

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 PC 13.3.15 DA 24 2-89  
**\*110\***  
 QC Memo 0.00  
 Quality Control 6x

120 QC5- Inspect part completeness to step on W/O 0.00 PC 13.3.15 DA 24 2-89  
**\*120\***  
 QC Memo 0.00  
 Quality Control 6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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\*82306\*

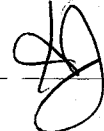
Page 2

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>U/A001</u>	0.00							
*130*									
Packaging	Memo	0.00						13-03-14	PD
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

13/3/20 

RB03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 82306

\*82306\*

Parent Item: D3826-041

\*D3826-041\*

Parent Item Name: Rib / Gusset Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1		Manufactured	No			100	Each	27.0000	1	4			
<b>*D2235-1*</b> Basket Rib													
**													
⑥ 13-03-12 PD													

Location	Loc Qty	Loc Code
WA	15	
78636	5	
81910	10	
WA005	12	
66895	4	
79153	8	

B90703

D3929-041		Manufactured	No			100	Each	10.0000	1	4			
<b>*D3929-041*</b> Gusset Assembly													
**													
⑥ 13-03-12 PD													

Location	Loc Qty	Loc Code
WA005	10	
77675	2	
79152	8	

B91630 -> 4  
B88525 -> 1  
B95161 -> 1

D3929-042		Manufactured	No			100	Each	12.0000	1	4			
<b>*D3929-042*</b> Gusset Assembly													
**													
⑥ 13-03-12 PD													

Location	Loc Qty	Loc Code
WA005	12	
77677	4	
79154	8	

B89213 -> 1  
B91586 -> 2  
B95063 -> 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

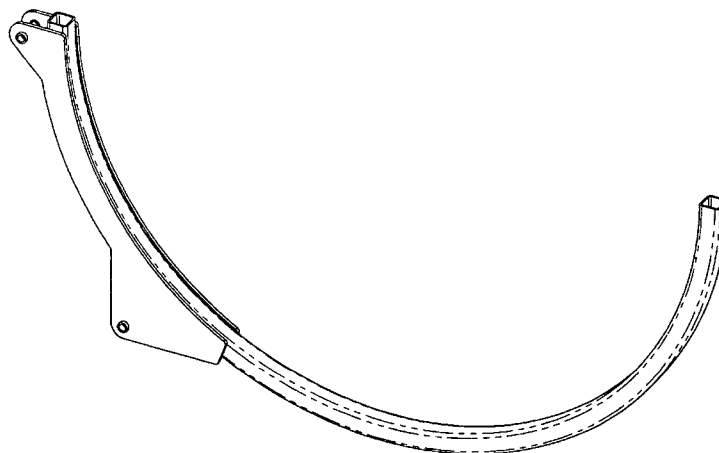
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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82306 MLJ  
12/03/28



**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
8/10/12 MLJ

B	D3929-041/042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B  
SHEET 1 OF 2  
TITLE **RIB/GUSSET ASSY** SCALE  
NTS

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- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 3.32 lbs

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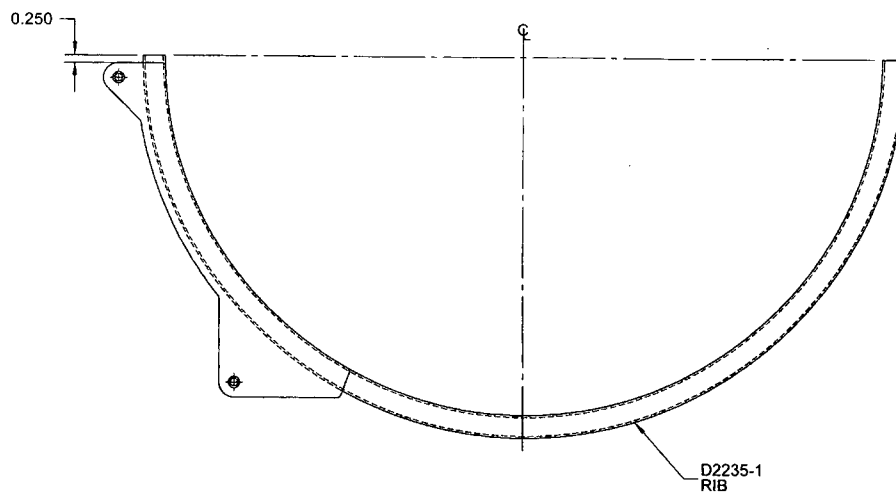
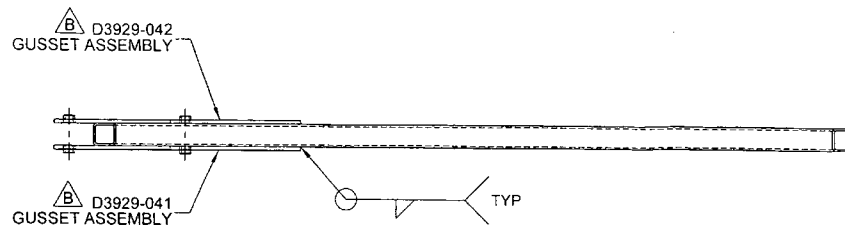
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82306



**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
9/04/16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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